

5/17

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22927
<b>Description:</b> Shaft Sleeve	<b>Part Number:</b>	D3233-7
<b>Dwg:</b> D3233 Rev. B	<b>Qty:</b>	9 <del>4</del>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.04.06	4
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1:375W.125) Identify for D3233-7. Batch: <u>M17015</u>	<i>[Signature]</i>	05/04/19	9
3	QC2	Inspect parts as they come off the machine Identify as D3233-7	<i>[Signature]</i>	05.05.04	9
4	QC8	Second check	<i>[Signature]</i>	05.05.04	9
5	CM	Deburr	<i>[Signature]</i>	05.05.04	9
6	QC5	Inspect work to Step 5	<i>[Signature]</i>	05.05.04	5
7	ST	Identify and Stock	<i>[Signature]</i>	05.05.04	9
8	AC	Cost / part <u>18.12</u>	<i>[Signature]</i>	05.05.05	9
9	DC	Close W/O <u>18.12</u> Inspect Level 21	<i>[Signature]</i>	05.05.10	9

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

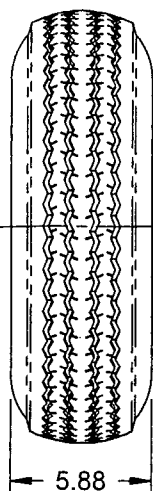
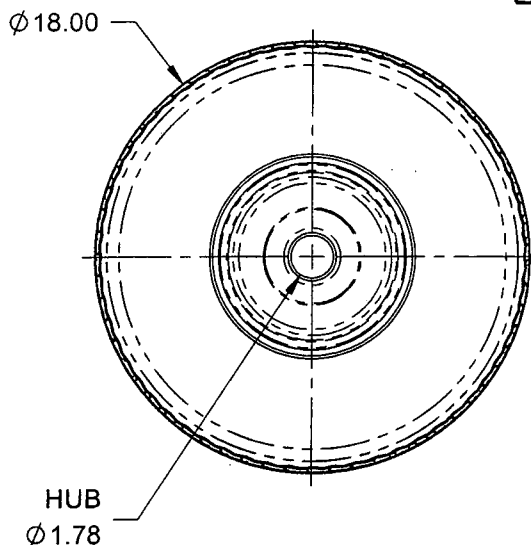
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

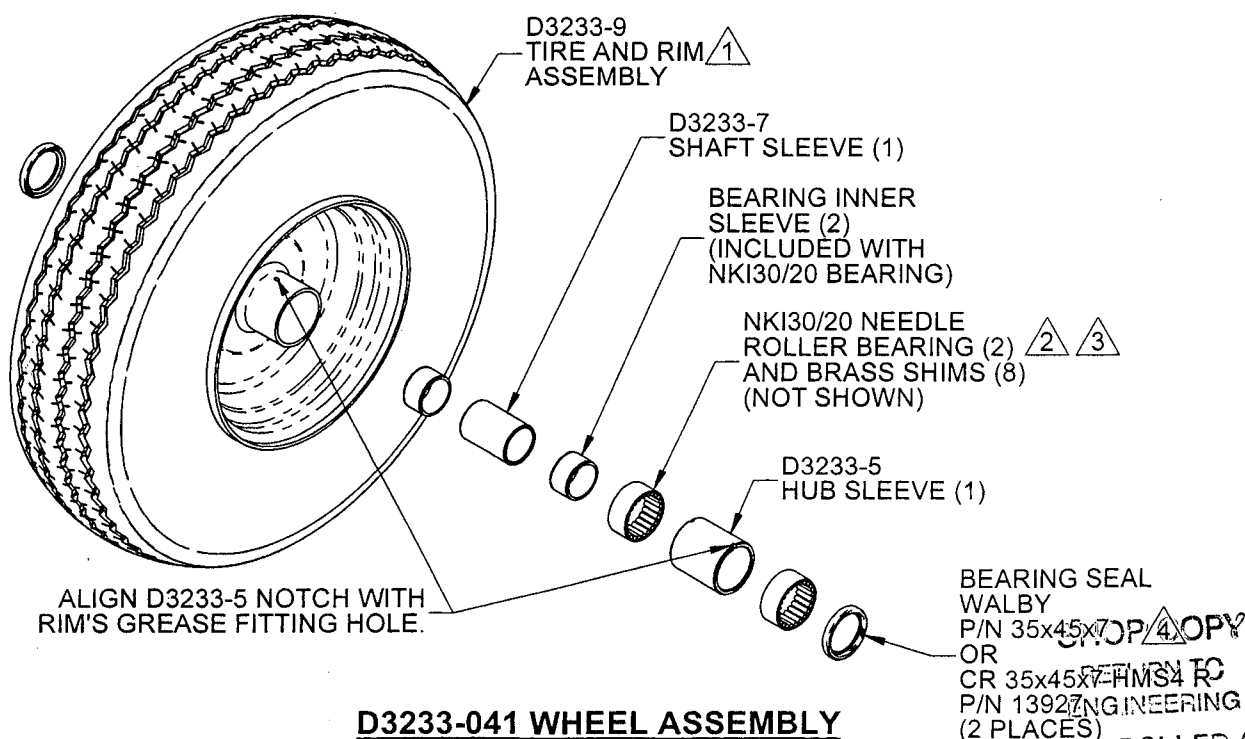
# PRELIMINARY ISSUE

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



## D3233-041 WHEEL ASSEMBLY

### NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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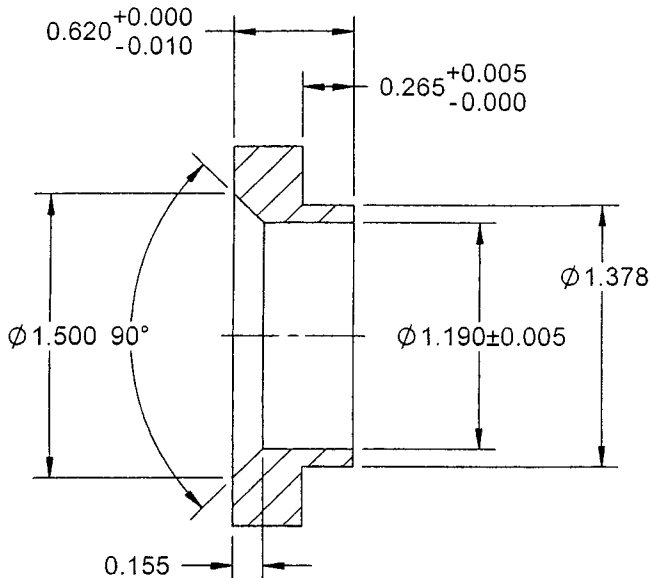
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WORK ORDER

NO. 22927

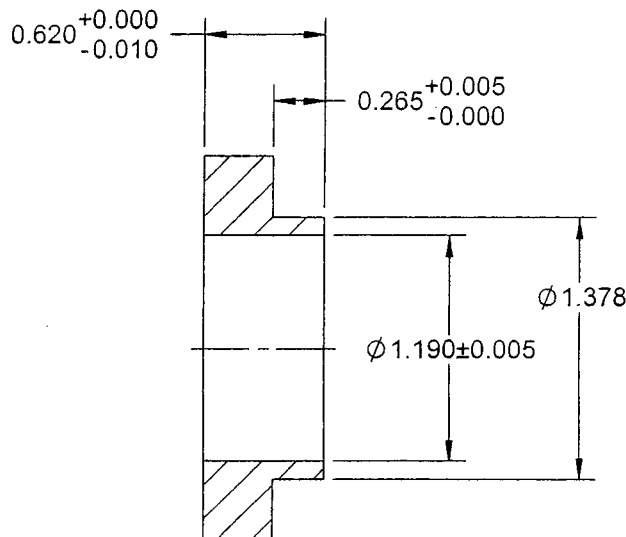
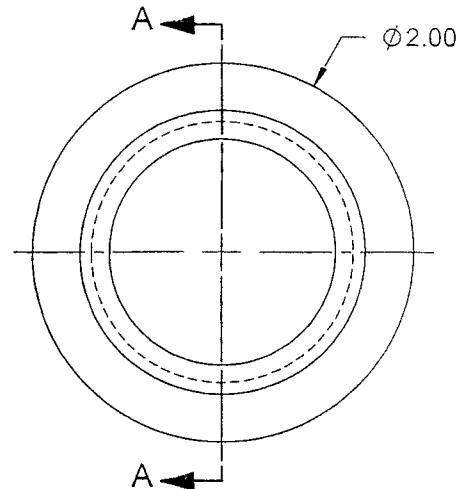
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1



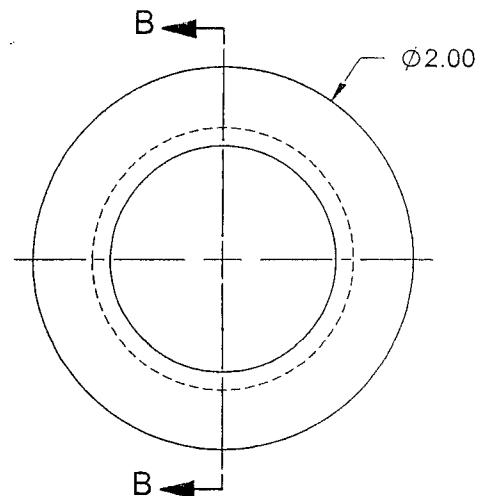
SECTION A-A

**D3233-1 INSIDE WASHER**



SECTION B-B

**D3233-3 OUTSIDE WASHER**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00T01 AMENDMENT MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS, NOTICE (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

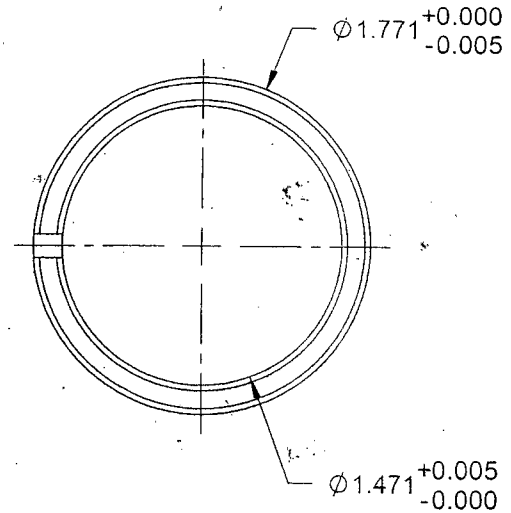
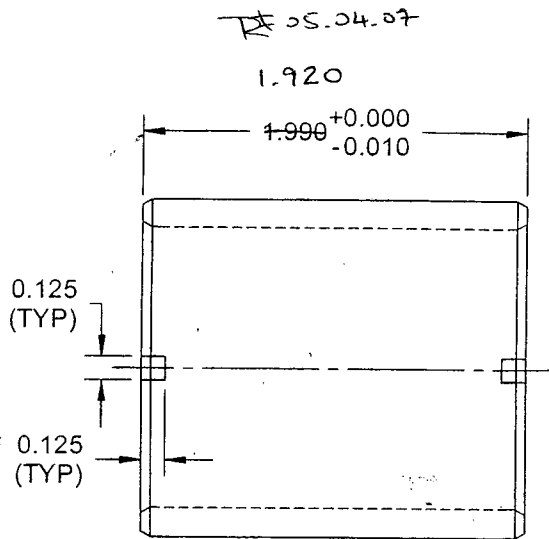
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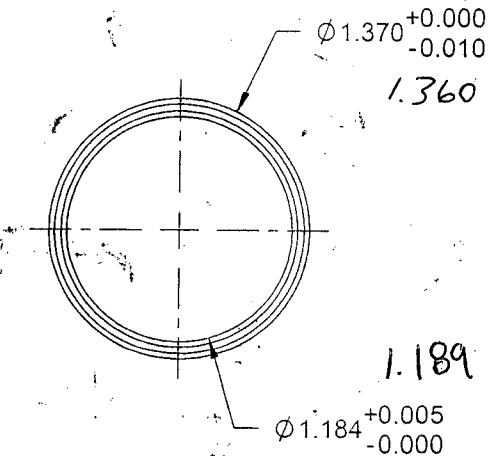
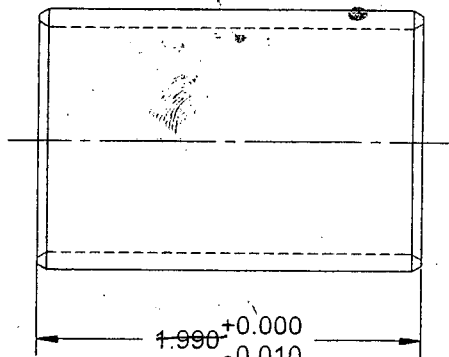
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CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1

**PRELIMINARY ISSUE**



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 CONTROLLED COPY MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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**WORK ORDER**

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 04, 2005  
12:27 pm

Work Order No : 0022927  
Project Name : D3233-7  
Project For : WK517  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3233-7  
Description : Shaft Sleeve  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 04-04-05  
Est Finish Date : 04-28-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00